

What is claimed is:

1. A molded door skin, comprising:

an exterior surface having outer portions lying on a first plane;

spaced grooves recessed from the plane of said outer portions;

5 tonal portions having a planar area and a plurality of spaced depressions
recessed from the plane of said planar area.

2. The door skin of claim 1, wherein said spaced grooves have variable depths
relative to the plane of said outer portions.

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3. The door skin of claim 2, wherein said spaced grooves are recessed from the
plane of said outer portions from between about 0.005 inches to about 0.015
inches.

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4. The door skin of claim 1, wherein said spaced grooves are variably spaced from
each other.

5. The door skin of claim 1, wherein said spaced grooves extend longitudinally
relative to each other.

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6. The door skin of claim 5, wherein said spaced grooves have variable lengths.

7. The door skin of claim 1, wherein the plane of said planar portion is coplanar with the first plane of said outer portions.

5 8. The door skin of claim 1, wherein said spaced depressions are recessed from the plane of said planar portions from between about 0.001 inches to about 0.003 inches.

9. The door skin of claim 1, wherein said tonal portions have differing densities of said depressions.

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10. The door skin of claim 1, wherein the door skin is manufactured from a material selected from the group consisting of sheet molding compound, polystyrene, polypropylene, steel, medium density fiberboard, hard board, fiberboard, and thermoplastic material.

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11. The door skin of claim 1, wherein said outer portions, said spaced grooves and said tonal portions from a wood grain pattern.

12. The door skin of claim 1, further comprising a stain on said exterior surface.

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13. A method of etching a wood grain pattern into a plate, comprising the steps of:
providing an image of a piece of wood having ticks and background tones;
providing a metal plate;

applying acid resist on a surface of the plate;
laser ablating the resist according to a tick image derived from the image;
applying acid to the plate according to the tick image to form ticks
having a first height;

5 repeating said applying acid resist, said laser ablating and said applying
acid steps to form some ticks having a second height, wherein the second height
differs from the first height;

applying acid resist on the surface of the etched plate;

laser ablating the resist according to a tonal image derived from the image;

10 and

applying acid to the plate, thereby etching the plate and forming the tonal
pattern in the plate.

14. The method of claim 13, including the further steps of:

15 providing a plurality of images of wood pieces;

arranging the plurality of images in a desired configuration.

15. The method of claim 14, wherein the desired configuration is an image of a door.

20 16. The method of claim 15, including the step of capturing a digital image of a piece
of wood.

17. The method of claim 16, comprising the further step of separating the digital image into at least two layering images, wherein each one of the layering images is an image of ticks having a modified width.

5 18. The method of claim 17, including the step of separating the image into three layering images.

19. The method of claim 13, wherein the first height is 0.015 inches or less.

10 20. The method of claim 13, wherein the second height is about 0.005 inches.

21. The method of claim 13, comprising the further step of subjecting the plate to an acid bath after said applying acid to the plate step.

15 22. The method of claim 13, including the step of cleaning the plate prior to said repeating step.

23. The method of claim 13, including the step of cleaning the plate after said repeating step.

20 24. The method of claim 13, comprising the further step of combining the image with a screen to create a tonal pattern image used to form the tonal pattern in the plate.

25. The method of claim 24, wherein the screen has between 133 lines per inch and 200 lines per inch.

5 26. The method of claim 13, including the step of sanding a wood piece prior to said providing step.

27. An etched plate for forming a wood grain pattern into a composition material, comprising:

10 an etched metal plate having lower portions lying on a first plane;
spaced ticks extending from the plane of said lower portions;
tonal areas having a plurality of channels, said channels defining a
plurality of spaced protrusions.

15 28. The etched plate of claim 27, wherein the plate is selected from the group consisting of copper, aluminum, cold rolled steel, and stainless steel.

29. The etched plate of claim 27, wherein the plate is 20 gauge copper.

20 30. The etched plate of claim 27, wherein said spaced ticks extend from the plane of said lower portions from between about 0.005 inches and 0.015 inches.

31. The etched plate of claim 27, wherein said spaced ticks are variably spaced from each other.

32. The etched plate of claim 27, wherein said spaced ticks extend longitudinally relative to each other.

5 33. The etched plate of claim 27, wherein said spaced ticks have variable lengths.

34. The etched plate of claim 27, wherein said channels have bases that are coplanar with the plane of said lower portions.

10 35. The etched plate of claim 34, wherein said protrusions extend from the plane of said bases from between about 0.001 to about 0.003 inches.

36. The etched plate of claim 27, wherein said tonal areas have differing densities of said protrusions.

15 37. The etched plate of claim 27, wherein the plate is fastened to a steel die face.

38. A molded construction component, comprising:

an exterior surface having outer portions lying on a first plane;

20 spaced grooves recessed from the plane of said outer portions;

tonal portions having a planar area and a plurality of spaced depressions recessed from the plane of said planar area.

39. The molded construction component of claim 38, wherein said spaced grooves have variable depths relative to the plane of said outer portions.

5 40. The molded construction component of claim 38, wherein said spaced grooves are recessed from the plane of said outer portions from between about 0.005 inches to about 0.015 inches.

41. The molded construction component of claim 38, wherein said spaced grooves are variably spaced from each other.

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42. The molded construction component of claim 38, wherein said spaced grooves extend longitudinally relative to each other.

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43. The molded construction component of claim 42, wherein said spaced grooves have variable lengths.

44. The molded construction component of claim 38, wherein the plane of said planar portion is coplanar with the first plane of said outer portions.

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45. The molded construction component of claim 38, wherein said spaced depressions are recessed from the plane of said planar areas from between about 0.001 inches to about 0.003 inches.

46. The molded construction component of claim 38, wherein said tonal portions have differing densities of said depressions.

5 47. The molded construction component of claim 38, wherein the door skin is manufactured from a material selected from the group consisting of sheet molding compound, polystyrene, polypropylene, steel, medium density fiberboard, hard board, fiberboard, and thermoplastic material.

10 48. The molded construction component of claim 38, wherein said outer portions, said spaced grooves and said tonal portions from a wood grain pattern.

49. A door, comprising:

a peripheral frame; and

15 at least one door skin, said door skin having an exterior surface with outer portions lying on a first plane, spaced grooves recessed from the plane of said outer portions, and tonal portions, said tonal portions having a planar area and a plurality of spaced depressions recessed from the plane of said planar area.

20 50. The door of claim 49, wherein the door has two of said door skins secured to opposing sides of said frame.